

dup Feb-10

Work Order ID 77937

\*77937\*

Page 1

December-22-11 2:47:48 PM

Item ID: D3267-043 Accept \*N9000040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Basket Lid Assembly (Inside)  
Start Date: 22/12/2011 Start Qty: 1.00 \*1\* Cust Item ID:  
Required Date: 01/02/2012 Req'd Qty: 1.00 \*1\* Customer:  
Reference:

Approvals: Process Plan: M.C.J Date: 11/12/22 Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3267	Rev C

100 Weld per dwg A/R S.S. rod Batch: M117884 0.00  
Large Fab

\*100\*

Large Fab

Large Fab

Memo 0.00

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-043 as per Dwg D3267

4-Deburr & Remove All Markings From Material

5-Weld D3267-043 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

PL 12.01.23 20 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*77937\***

Page 2

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 22/12/2011    **Start Qty:** 1.00    **\*1\***

**Required Date:** 01/02/2012      **Req'd Qty:** 1.00      **\*1\***

**Reference:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

**Insp.  
Stamp**

0.00

**\*110\***

0.00

0.00

**\*120\***

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 77937****\*77937\***

Page 3

Item ID: D3267-043

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Basket Lid Assembly (Inside)

Start Date: 22/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*130\***

Powdercoat

Memo

0.00

Powder Coating

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST

START TIME: 11:30OVEN TEMPERATURE: 400°FFINISH TIME: 12:00

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

*1X 12/01/25*

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*1 BL 12-1-26**muay80*

W/O:		WORK ORDER CHANGES					
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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145	Identify as per dwg & Stock Location:	0.00							
<b>*145*</b>						1			
Packaging	Memo	77936							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

12/11/309J  
 12-01-27  
 1

W/O:		WORK ORDER CHANGES					
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# Picklist Print

December-22-11 2:47:53 PM

Page 1

Work Order ID: 77937

**\*77937\***

Parent Item: D3267-043

**\*D3267-043\***

Parent Item Name: Basket Lid Assembly (Inside)

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Removed -041 05-11-04 JLM  
IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified  
by:EC  
IPP Rev:E add I.D. DD 10.03.11 verified by:EC IPP Rev:F  
reverse order of seq. 150, 155 DD 10.04.07 Verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-3 <b>*D3166-3*</b> Basket Hoop		Manufactured	No			100	Each	3.0000	0	0			
				<u>Location</u>				<u>Loc Qty</u>					
				WA007				3					
				73627				3					
D3182-1 <b>*D3182-1*</b> Hinge		Manufactured	No			100	Each	16.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>					
				WA				16					
				76657				6					
				77316				10					
D3442-3 <b>*D3442-3*</b> Shim		Manufactured	No			100	Each	6.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>					
				WA005				6					
				77476				6					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*D3267-043\***

Parent Item Name: Basket Lid Assembly (Inside)

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100 f

186.7507 7 7.368421

**\*M304TS0 750W 065\***

304 SQ Tube .75x.75x.065W

\*\*

*12.01.19*

## Location

## Loc Qty

## Loc Code

MAT018

165.0864785

117636

67.9987

118773

97.0877785

WA007

15.5974906

116267

14.628472

116763

0.9690186

WA035

6.0667

118181

6.0667

M304EX0.75-16F

Purchased

No

110 sf

595.5774 4.3 4.526316

**\*M304EX0 75-16F\***

Expanded Metal Flat SS

\*\*

*12.01.23*

## Location

## Loc Qty

## Loc Code

WA

0.0001156

119180

0.0001156

WA035

595.577296

117197

102.9036

117896

38.3264

118153

76.8473

118245

3.0983

118497

21.06788

118955

82.17

119180

64.537916

119729

206.6259

*1120153 → 4.5263*

W/O:		WORK ORDER CHANGES					
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QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 77937-M.C-5  
11/12/22

RELEASED  
08-09-14



#### NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065  
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3267	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BASKET LID ASSEMBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

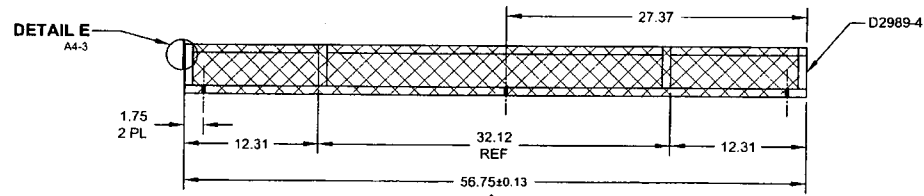
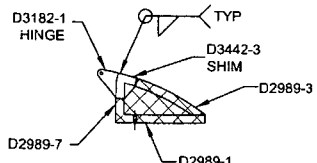
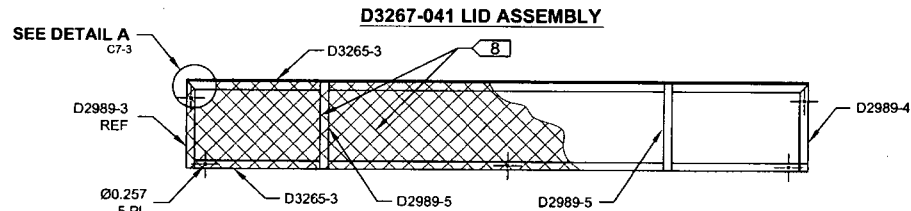
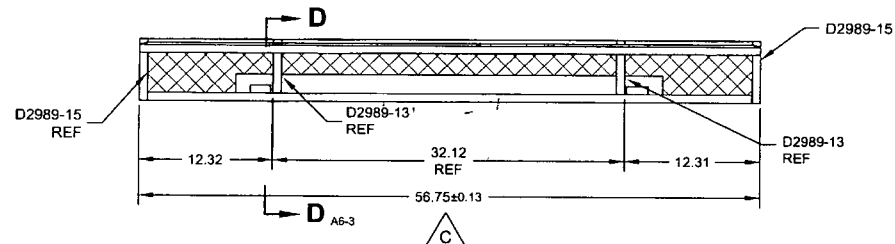
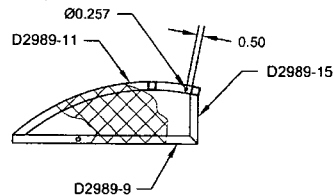
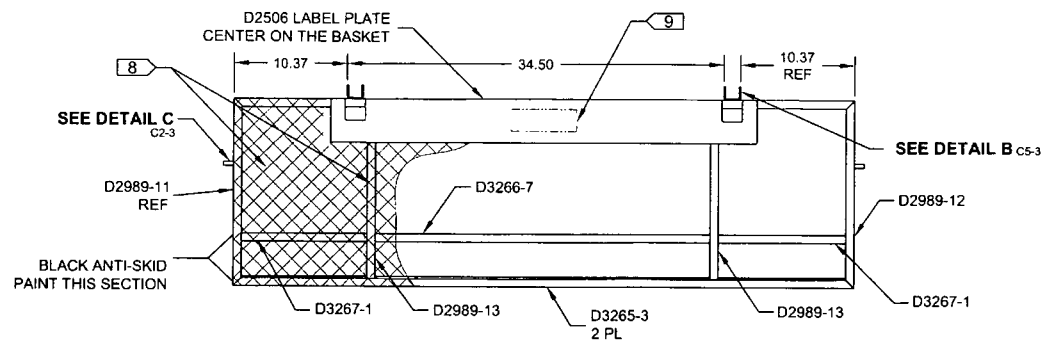
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

77937



**NOTES:**

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
- 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

RELEASED  
08-07-04/17

**D3267-041 LID ASSEMBLY**

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3267	REV. C
MFG. APPR.		TITLE BASKET LID ASSEMBLY	2 OF 3
APPROVED			SCALE NTS
DE APPR.			
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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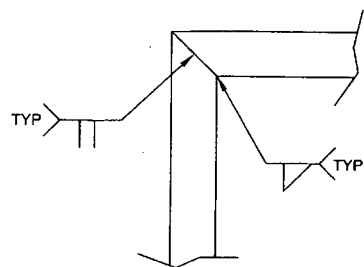
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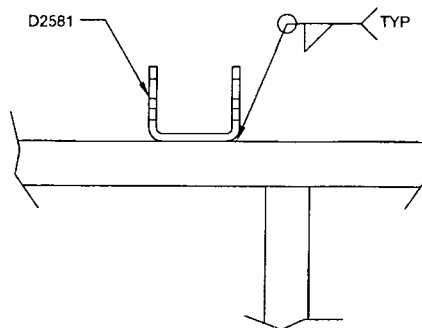
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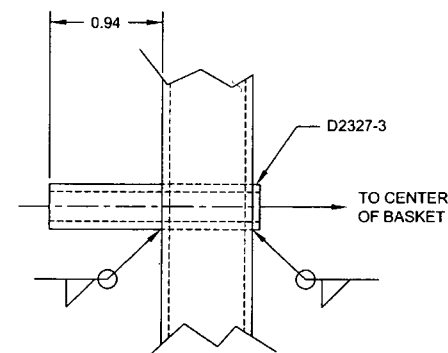
77937



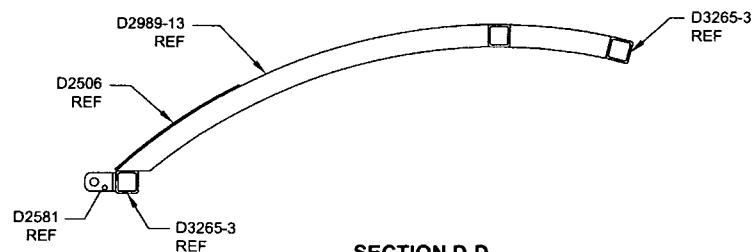
**DETAIL A** B5-2  
JOINT WELD DETAIL TYP  
SCALE 2X



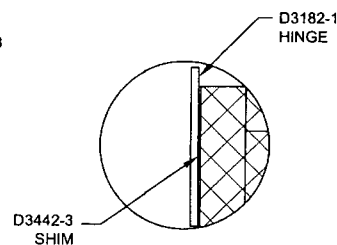
**DETAIL B** D2-2  
2 PL  
SCALE 2X



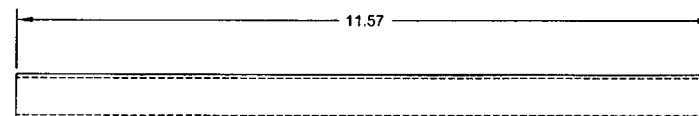
**DETAIL C** D5-2  
SPACER INSTALLATION  
SCALE 4X



**SECTION D-D** C4-2



**DETAIL E** B6-2  
SCALE 2X  
2 PL



**D3267-1 STRUT**  
SCALE 2X

**RELEASED**  
08.07.14

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSMBLY	NTS
DATE	08.08.15	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR REPRODUCTION IN ANY FORM WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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